

Work Order ID 52663-1

October 6, 2009 7:40:02 AM

Page 1

Item ID: D2646

Accept

Setup Start

Revision ID: C

Stop

Item Name: Aft Cap

Start Date: 10/06/09 Start Qty: 50.00

Required Date: 10/20/09 Req'd Qty: 50.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *CL* Date: *09/10/06* Tooling:

Run Start

QC: Date: SPC (Y/N):

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D2646	Rev C
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100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: *10531* 11-Spin as per Dwg D2646 12-Material release note required

pl 09-10-4

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

104/10/21 (50)

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

27 8 Oct 12

centos
(+58)

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Page 2

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Stop



Start Date: 10/06/09

Start Qty: 50.00



Cust Item ID:

Required Date: 10/20/09

Req'd Qty: 50.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

0.00

0.00

1-Drill using DT8026 as per Dwg D2646. 2-Open holes to .297 as per Dwg D2646. 3-Deburr

09/10/27 30

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

2) 5010/27

cents
750

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

WMO 09/11/03

X20

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Start Date: 10/06/09 Start Qty: 50.00



Cust Item ID:

Required Date: 10/20/09 Req'd Qty: 50.00

Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat
Powder Coating

spray paint

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

Formie B110918

spray paint Deflect Blue
clear Deflect

m 09 11 09 (20)

B110077

B113053

170

QC3- Inspect Part Finish

0.00



QC

Quality Control

QC14

Memo

0.00

zc 09-11-12 (x20)

180

Small Fab

0.00



Small Fab

Small Fab

Memo

Install inserts as per Dwg D2646

0.00

BP 09-11-12

(20)

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Cust Item ID:

Required Date: 10/20/09 Req'd Qty: 50.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

ml 02 11 12 (20)

200

Identify as per dwg & Stock Location:

FR-7

0.00



Packaging

Memo

0.00

Packaging

BK 09-11-12

(20)

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/13
UMF
09-11-12

Picklist Print

October 6, 2009 7:40:01 AM

Page 1

Work Order ID: 52663

Parent Item: D2646RevC

Parent Item Name: Aft Cap

Comments:

Start Date: 10/06/09

Required Date: 10/20/09

Start Qty: 50.00

Required Qty: 50.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS7-1032-130		Purchased	No			110	Each	3,056.000	100.0000			



Insert

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST 110511	3056	
105855	16	
108606	52	
111529	1488	
111779	500	
112772	1000	

D2646PRevC

Purchased

No

180

Each

0.0000

50.0000



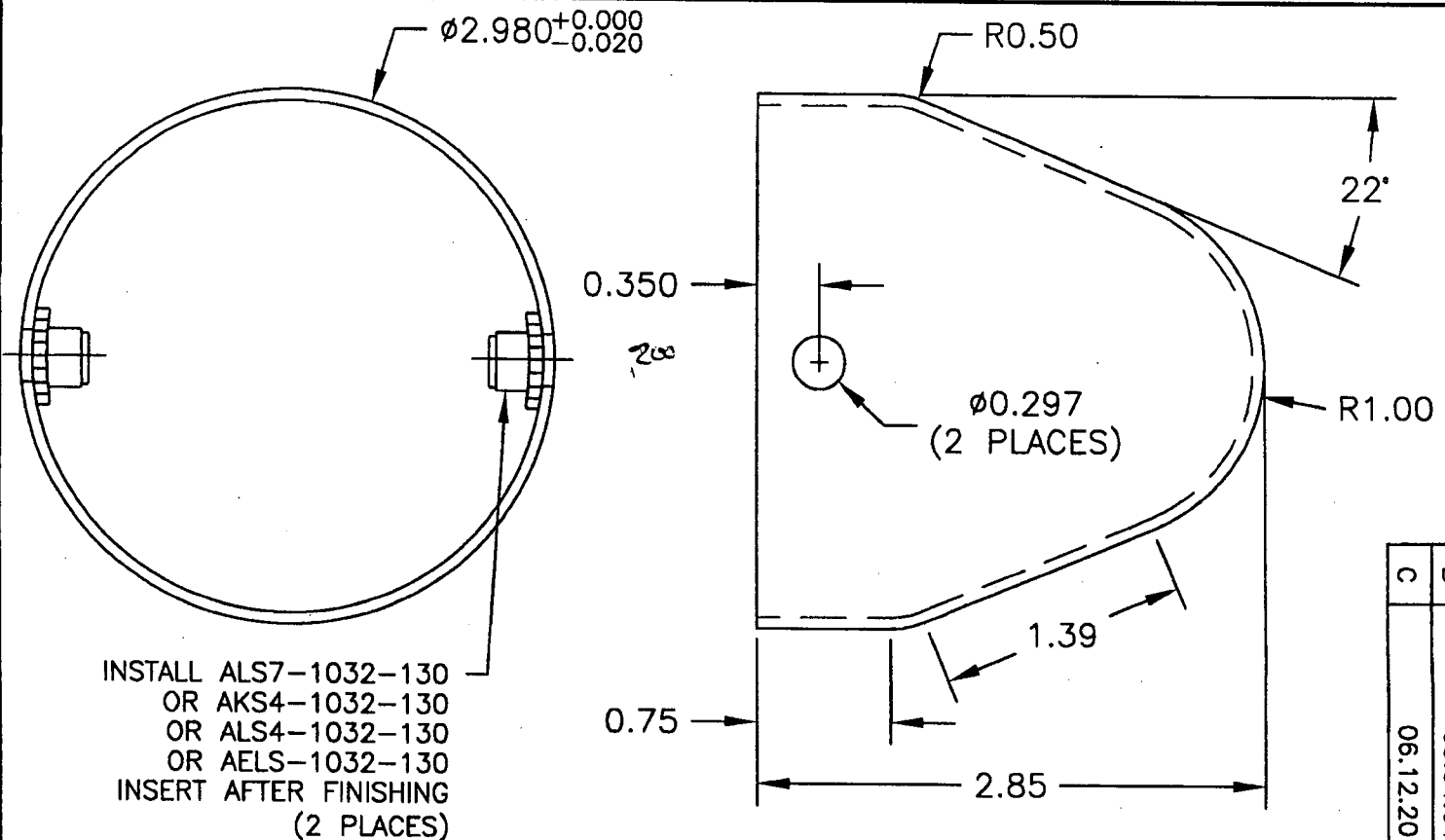
Aft Cap

110 BR 09-11-12

52663 mr
09-11-12



DESIGN	DS	DRAWN BY	PH	DART AEROSPACE USA, INC.	PORT HADLOCK, WA	REV. C
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	D2646	SHEET 1 OF 1
DATE	06.12.20	TITLE	AFT CAP	SCALE	1:1	
A	97.03.25	NEW ISSUE				
B	05.04.01	CHANGE TO CLOSED INSERTS				
C	06.12.20	CHANGE TO OPEN ENDED INSERTS				



INSTALL ALS7-1032-130
OR AKS4-1032-130
OR ALS4-1032-130
OR AELS-1032-130
INSERT AFTER FINISHING
(2 PLACES)

D2646 AFT CAP

- 1) MATERIAL: ALUMINUM 1100-0 0.063 THICK (QQ-A-250/1)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52663

RELEASED
07.02.12



Sieg's Manufacturing Ltd.
Metal Spinning and Fabricating

6236 - 205 STREET, LANGLEY, B.C. V2Y 1N7
TELEPHONE: (604) 530-7455 • Fax: (604) 530-7490

Packing Slip

Packing Slip No.: 37189
Date: 10/20/2009
Page: 1

Sold to:	Ship to:
DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7	DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7
Order No.: 10531	Sold By: KAULBARS, KALE
Shipped By: <i>EA ex.</i>	Ship Date: 10/20/2009
Tracking No.:	

Item No.	Unit	Description	Quantity
D2646P +	EACH	AFT CAPS <i>S</i> <i>6/10/22</i>	<input checked="" type="checkbox"/> 50
Comment:			



Sieg's Manufacturing Ltd.

Metal Spinning and Fabricating

6236 - 205 STREET, LANGLEY, B.C. V2Y 1N7

TELEPHONE: (604) 530-7455 • FAX: (604) 530-7490

INSPECTION REPORT

Date: Oct. 20/09

Customer: Dart Aerospace

Packing Slip: 37189

Part#:	Quantity	Material	Check holes	Debur edges	Insp. By.
D2646P	50	4GA	N/A	✓	R

Notes:

Material Certification Attached: Yes.

Verified by ThyssenKrupp Materials NA, Anna Riggs

Quantity: 3154 LB

Cust PO#: 717

Customer: SIEGS MANUFACTURING LTD. ***

(1 of 1)

2008-04-21

Shipper#: U47541

Cust Part#:

PRECISION COIL, INC.Post Office Box 2650
U.S. 50 West
Clarksburg, WV 26302
(304) 622-1984
(304) 622-2301

7/10/2007

CS 1775

CERTIFIED INSPECTION REPORT

Report No. 31657

Test Date 7/10/2007

Lot # / Heat # / S/O # 76086

Alloy 1100

Temper O

Gauge (in) .063

Width (in) 48

Length (in) 144.000

Net Weight (lbs) 10,522# 'S

Customer Name COPPER & BRASS SALES

Customer PO # CS1775

Test Specification AMSQQA250/1A &
ASTMB209-06

S 08/10/07

Test No	Spec ID	YLD (psi)	UTS (psi)	ELONG in 2" (%)
38480	1100-O	5,714	13,038	33.00

ALLOY	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	OTHER		Al
									EACH	TOTAL	
1100	Si+Fe	=.95	.05-.20	.05	---	---	.10	---	.05	.15	89.10 Min
ACTUALS											
	.12	.60	.10	---	---	---	.01	---	.05	.15	REMAINDER

THIS REPORT INDICATES THE CHEMICAL ANALYSIS RANGE TO WHICH THE ITEMS LISTED WERE MANUFACTURED BASED ON CERTIFICATE OF COMPLIANCE FURNISHED TO US BY THE PRODUCER. WE CERTIFY THEM TO BE WITHIN THE LIMITS SHOWN. FOR ALLOY 1350 ONLY A MINIMUM ELECTRICAL CONDUCTIVITY OF 62% I.A.C.S. AT 20 DEGREES CELSIUS IS GUARANTEED.

By:

UNCL, UNCL

Date:

7/13/07

DART
aerospaceDart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO10531

Purchase Order Date 06/10/2009

PO Print Date 06/10/2009

Page Number 1 of 1

Order From :

VC-SIE001

SIEG'S MANUFACTURING LTD.
6236 - 205 STREET
LANGLEY, BC V2Y 1N7
CAContact Name
Vendor Phone 604 530 7455
Vendor Fax 604 530 7490
Vendor Account NbrBuyer Chantal Lavoie
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency CAD
FOB

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2646P C	Aft Cap	06/10/2009 Yes	50.00 Each	Yours ppd	\$5.3500	\$267.50

Special Inst: As per DWG D2646 Rev C

PO Total:

\$267.50

FAXED
07/10/09
297MATERIAL CERTIFICATION
REQ'D UPON DELIVERYCERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

Change Nbr:

2

Change Date:

06/10/2009

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable